

Date: Thursday, 31/07/2008 12:17:55 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	STRUT
<b>Job Number</b> :	40845		
<b>Estimate Number</b> :	10275		
<b>P.O. Number</b> :		<b>Part Number</b> :	D2565103
<b>This Issue</b> :	31/07/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2565 REV E
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	38028	<b>Drawing Revision</b> :	E
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :	<u>JUL 08.8.01</u>	<b>Due Date</b> :	08/08/2008
<b>Comment</b> :	Est: F02.04.16 Added dwg Rev.C1 NG	<b>Qty:</b>	10 Um: Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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**Comment:** Qty.: 1.5934 f(s)/Unit Total: 15.9338 f(s)

304 RD TUBE .750 X.49W

304/316/318-2B Seamless Tubing, 3/4" O.D. x 0.049" wall

(M304TR0750W049)

Batch M 108 846

SB 07/08/27

(10)

2.0	BRAKE NC	NC BRAKE
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**Comment:** BRAKE NC

Punch to length as per Dwg D2565 using DT8313

SB 07/08/27

(10)

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Drill hole open to .316 Ø as per Dwg D2565 (one end only)

2-Deburr

F 08/08/28 @ HM

4.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

2 08/08/28 @ HM

5.0	POWDER COATING	POWDER COATING
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**Comment:** POWDER COATING

Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:50  
400  
2:20

M. 08/09/02

(10x)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 31/07/2008 12:17:55 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 40845

Part Number: D2565103

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-09-03 (10)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 270

DS 08/09/03 (10)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/03 (10)

Job Completion



MF 08-09-03

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2565-103 PAR #: N/A Fault Category: Prod / Finishing NCR: (Yes) No DQA: D Date: 08/09/05  
D205-633 QA: N/C Closed: D Date: 08/09/05

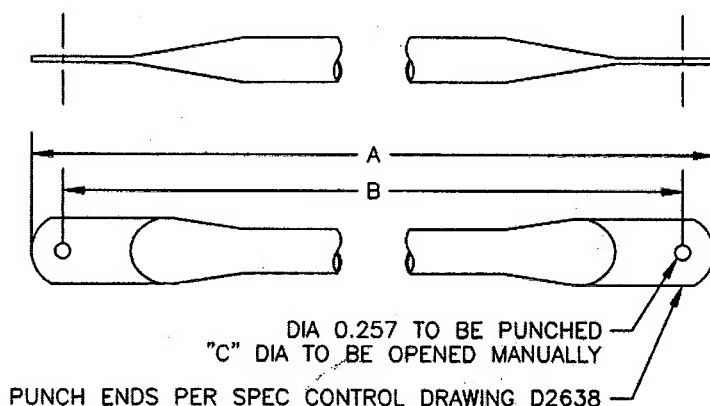
NCR: <u>40845</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/9/2	6.0	on three struts it was found with ink from the mat. showing through the powder coat. only in small areas	<i>[Signature]</i>	scuff all three with 320 grit sand paper. AND clean with acetone.	<i>[Signature]</i> 08-09-02 +3	<i>[Signature]</i> 08/09/03	<i>[Signature]</i>	<i>[Signature]</i> 8/9/2
			<i>[Signature]</i>	Re powder coat as per QS 7005	<i>[Signature]</i> 08/09/03 (3)	<i>[Signature]</i> 08/09/03	<i>[Signature]</i>	<i>[Signature]</i> 8/9/2

NOTE: Date & initial all entries



DESIGN		DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05				TITLE STRUT	SCALE 1:3
A	96.05.03	NEW ISSUE			
B	97.03.15	CORRECT D2565-111 DIM. A			
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)			
D	02.06.05	ADD -3XX PARTS; ADD FINISH			
E	04.05.05	ADD D2565-401-411; RMV ANGLE D			

RELEASED  
04.05.05



PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

#### GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL  
(REF DART SPEC. M304TR0.750W0.049)  
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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NO. 40845

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